

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000945**Date Inspected:** 27-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Lefeng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 77M, 89M Tower Mock Up & SAS Plates**Summary of Items Observed:**

Tower Mock Up:

Bay 2:

The Caltrans Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower Mock Up.

77M:

The QA Inspector observed ZPMC welding personnel performing heat straightening operations on 77M Lower Diaphragm SA95. The following photograph provides additional detail.

89M:

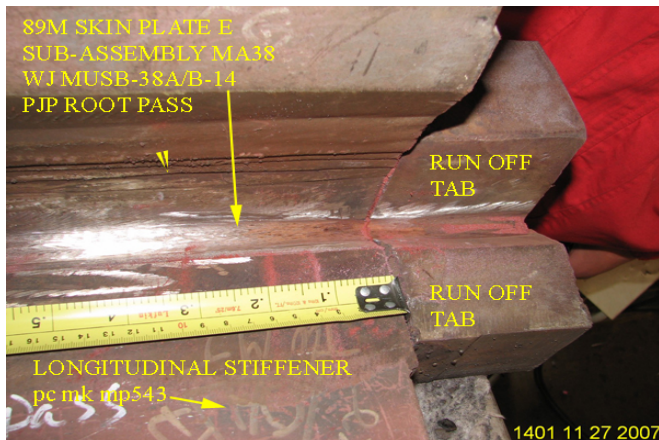
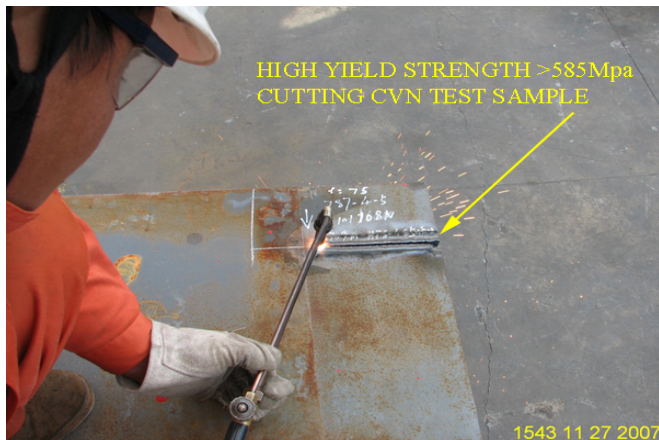
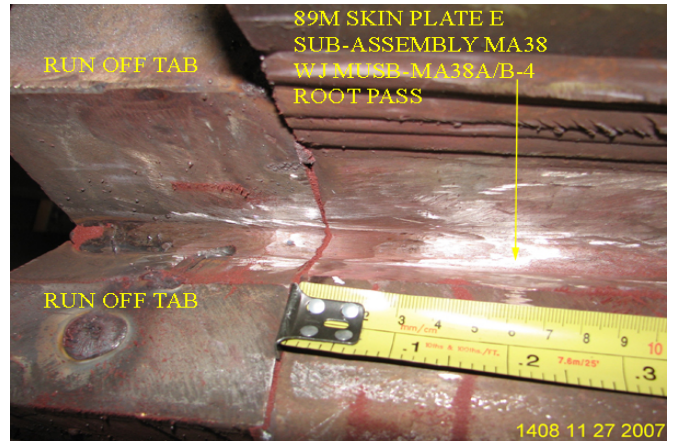
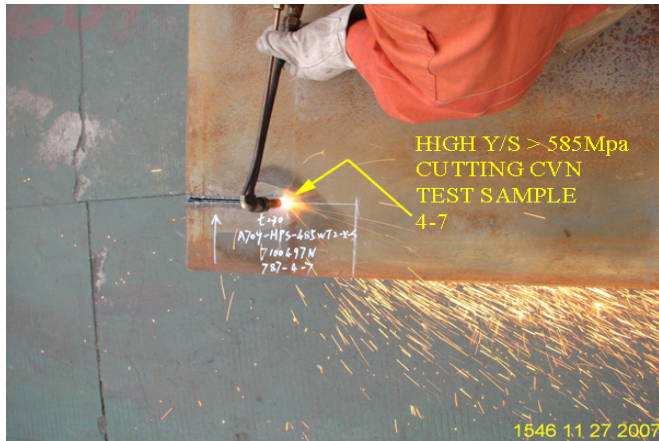
The QA Inspector randomly observed ZPMC Non Destructive Technicians Cai Xin Xin and Zhou Dongyun, performing MT examination on 100% of the full lengths of the root passes of Partial Joint Penetration (PJP) WJ's MUSB-MA38A/F-4 and MUSB-MA38A/F-14 on 89M Skin Plate E, Sub Assembly MA38. The QA Inspector performed a 20% random MT examination of the above welds. There appeared to be no indications and ZPMC QC accepted the root passes of WJ's MUSB-MA38A/F-4 and MUSB-MA38A/F-14. The following photographs provide additional detail.

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Storage Yard:

The QA Inspector randomly observed ZPMC personnel torch cutting 5 out of 19 samples from A709M-HPS-485WT2-Z Steel Plate to be used for Charpy V-Notch (CVN) Testing. American Bridge/Fluor Enterprises, a JV Representative Jeff Evans, informed the QA Inspector that the samples were being taken due to Yield Strengths in excess of 585 Mpa. The QA Inspector observed the cutting of CVN Samples 787-4-1, 787-4-3, 787-4-5, 787-4-7 and 787-4-19. The following photographs provide additional detail.



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Summary of Conversations:

There were no relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Franco,Charlie	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
